

# *Grizzly* **Industrial, Inc.**®

## **MODEL G5771 50" SLIP ROLL 16 GAUGE OWNER'S MANUAL**



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE  
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#JB10625 PRINTED IN CHINA

 **WARNING!**

**This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.**

**Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.**

**The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.**

**The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.**

 **WARNING!**

**Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:**

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

**Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.**

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# INTRODUCTION

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## Foreword

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We are proud to offer the Model G5771 50" Slip Roll. This machine is part of a growing Grizzly family of fine metalworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

The specifications, drawings, and photographs illustrated in this manual represent the Model G5771 when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

## Contact Info

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We stand behind our machines. If you have any service questions, parts requests or general questions about the machine, please call or write us at the location listed below.

Grizzly Industrial, Inc.  
1203 Lycoming Mall Circle  
Muncy, PA 17756  
Phone: (570) 546-9663  
Fax: (800) 438-5901  
E-Mail: techsupport@grizzly.com

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.  
c/o Technical Documentation Manager  
P.O. Box 2069  
Bellingham, WA 98227-2069  
Email: manuals@grizzly.com

## Functional Overview

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The Model G5771 50" Slip Roll is used to form sheet metal. A series of heavy metal rollers joined by gears and adjusted by hand knobs allow the user to flatten or create bends in metals up to 16 gauge thickness.

For flattening workpieces, the upper and lower rollers are adjusted to a thickness just slightly smaller than the thickness of the workpiece. The workpiece is then fed through the upper and lower rollers with the rear lowered out of the way. This process is repeated until the desired thickness or straightness is achieved.

For creating bends in workpieces, the sheet metal is first placed between the upper and lower roll bars. The lower roll bar is then adjusted to the thickness of the workpiece.

The workpiece is then fed through the upper and lower rollers and into the rear roller. By turning the radius adjustment knobs, the rear roller can be raised, forming a bend in the workpiece.

The user then turns the hand crank, processing the workpiece through the machine. A uniform radius curve is bent into the remaining length of the workpiece.

Tighter radius curves can be created by raising the rear roller and larger radius curves can be created by lowering the rear roller. Cones can be created by setting the ends of the rear roller at different heights.

Small diameter tubing and wire can be shaped using the wire channels located on one end of the lower and rear roller.

The upper roller is easily removed to allow unloading of cylindrical-shaped final workpieces.



# Identification

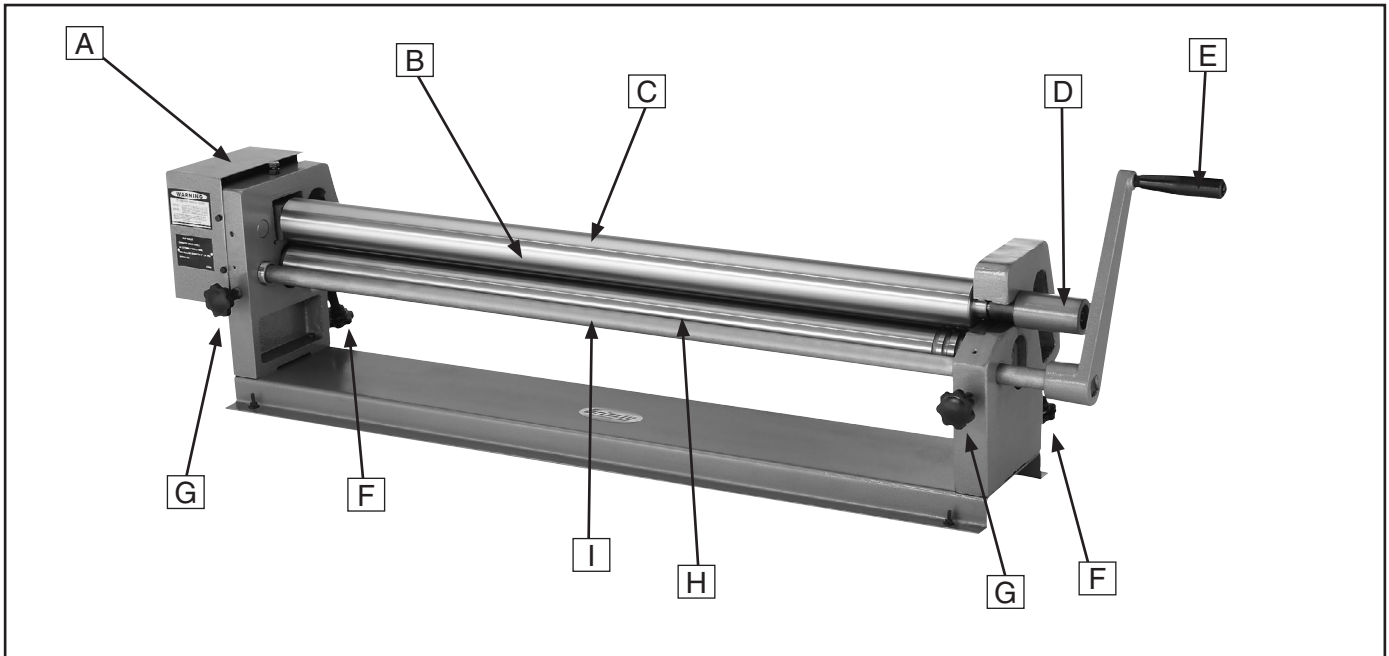


Figure 1. Identification.

## Identification List (Figures 1 and 2)

- A. Gear Assembly Cover
- B. Upper Roller
- C. Rear Roller
- D. Removable Bushing
- E. Crank
- F. Radius Adjustment Knob
- G. Thickness Adjustment Knob
- H. Lower Roller
- I. Crank Shaft Roller

## Sample Illustration (Figure 2)

Throughout this manual, diagrams are used to illustrate how the components of the machine are used during the various steps of operation.

Familiarize yourself with the following illustration, its relationship to the machine, and the symbols used in it before proceeding through this manual.

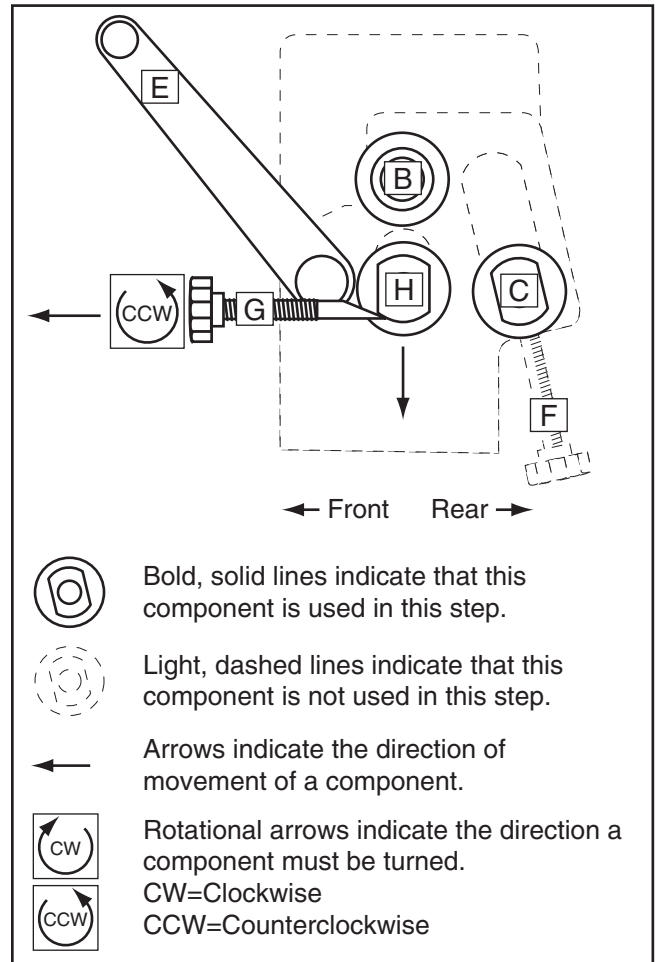


Figure 2. Sample Illustration.





# MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

## GRIZZLY MODEL G5771 50" SLIP ROLL

Design Type ..... Bench Model

**Overall Dimensions:**

Height (with Handle in Center Position) ..... 22"  
Crate Size ..... 22<sup>1</sup>/<sub>2</sub>" x 16" x 69"  
Footprint ..... 55" x 12"  
Shipping Weight ..... 561 lbs.

**Capacities:**

Roll (min) ..... 3" Dia in 16-Gauge Mild Steel  
Wire Sizes ..... <sup>5</sup>/<sub>16</sub>", <sup>3</sup>/<sub>8</sub>", <sup>1</sup>/<sub>2</sub>"  
Max Capacity ..... 50"

**Construction:**

Rollers ..... Precision Ground Cast Iron  
Frame ..... Cast Iron

**Features:**

..... Quick Release Top Roller  
..... Hardened Steel Gearing



# SECTION 1: SAFETY

## WARNING

### For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

**NOTICE**

This symbol is used to alert the user to useful information about proper operation of the machine.

## WARNING

### Safety Instructions for Machinery

- 1. READ THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses—they are NOT safety glasses.
- 3. ALWAYS WEAR A NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.** Most types of dust (wood, metal, etc.) can cause severe respiratory illnesses.
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing loss.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry that can catch in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



# WARNING

## Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILDPROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIGHTED.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Grounded cords minimize shock hazards. Undersized cords create excessive heat. Always replace damaged extension cords.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding or misaligned parts, broken parts, loose bolts, and any other conditions that may impair machine operation. Repair or replace damaged parts before operation.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. Improper accessories increase risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Maintain stability and balance at all times.
23. **MANY MACHINES CAN EJECT WORKPIECES TOWARD OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **CERTAIN DUST MAY BE HAZARDOUS** to the respiratory systems of people and animals, especially fine dust. Be aware of the type of dust you are exposed to and always wear a respirator designed to filter that type of dust.





## **WARNING**

# Additional Safety for Slip Rolls

- 1. METAL EDGES.** Always chamfer and deburr sharp metal edges before inserting them into the slip roll. Sharp edges on sheet metal can cause severe cuts.
- 2. HAND PROTECTION.** Always wear leather gloves when using this tool.
- 3. PINCHING HAZARD.** Keep fingers out of roller path during operation.
- 4. CRUSHING HAZARD.** Make sure rollers and workpieces are fully supported during installation and removal. Wear steel toed footwear during operation to protect your feet if you drop a roller or workpiece.
- 5. EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact Tech Support at (570) 546-9663.

## **WARNING**

Like all machinery there is potential danger when operating this machine. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

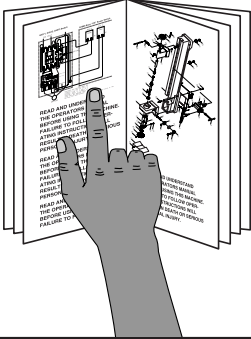
## **CAUTION**

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.



# SECTION 2: SETUP

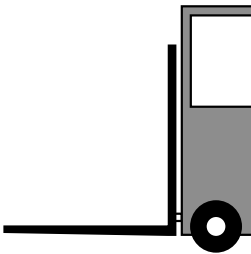
## Setup Safety



**!WARNING**  
This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



**!WARNING**  
Wear safety glasses during the entire setup process!



**!WARNING**  
This machine and its components are very heavy. Get lifting help or use power lifting equipment such as a forklift to move heavy items.

## Items Needed for Setup

The following items are needed to complete the setup process, but are not included with your machine:

Description	Qty
• Power Lifting Equipment (Rated for at least 600 lbs) .....	1
• Lifting Straps (Rated for at least 600 lbs.) .....	2
• Assistants .....	As needed
• Safety Glasses (For each assistant) .....	1

## Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover the machine is damaged, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.

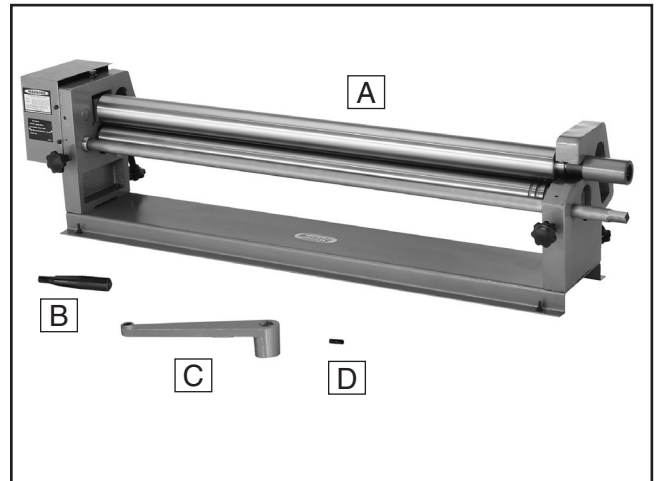


# Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

**Note:** *If you can't find an item on this list, check the mounting location on the machine or examine the packaging materials carefully. Occasionally we pre-install certain components for shipping purposes.*

Box 1: (Figure 3)	Qty
A. Slip Roll .....	1
B. Crank Handle .....	1
C. Crank .....	1
D. Set Screw M5-8 x 20.....	1



**Figure 3.** Inventory.

If any nonproprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.



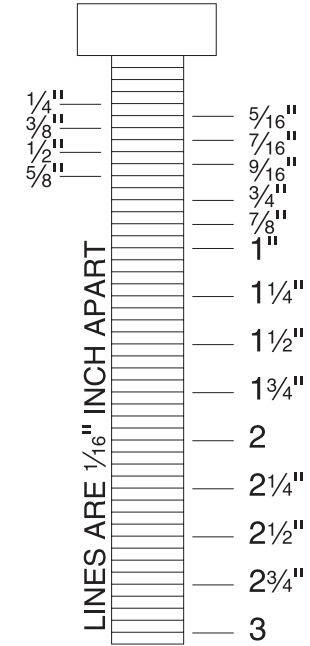
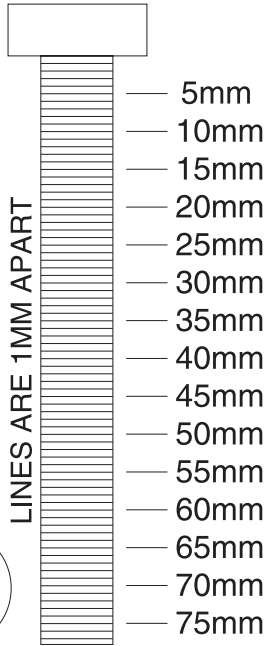
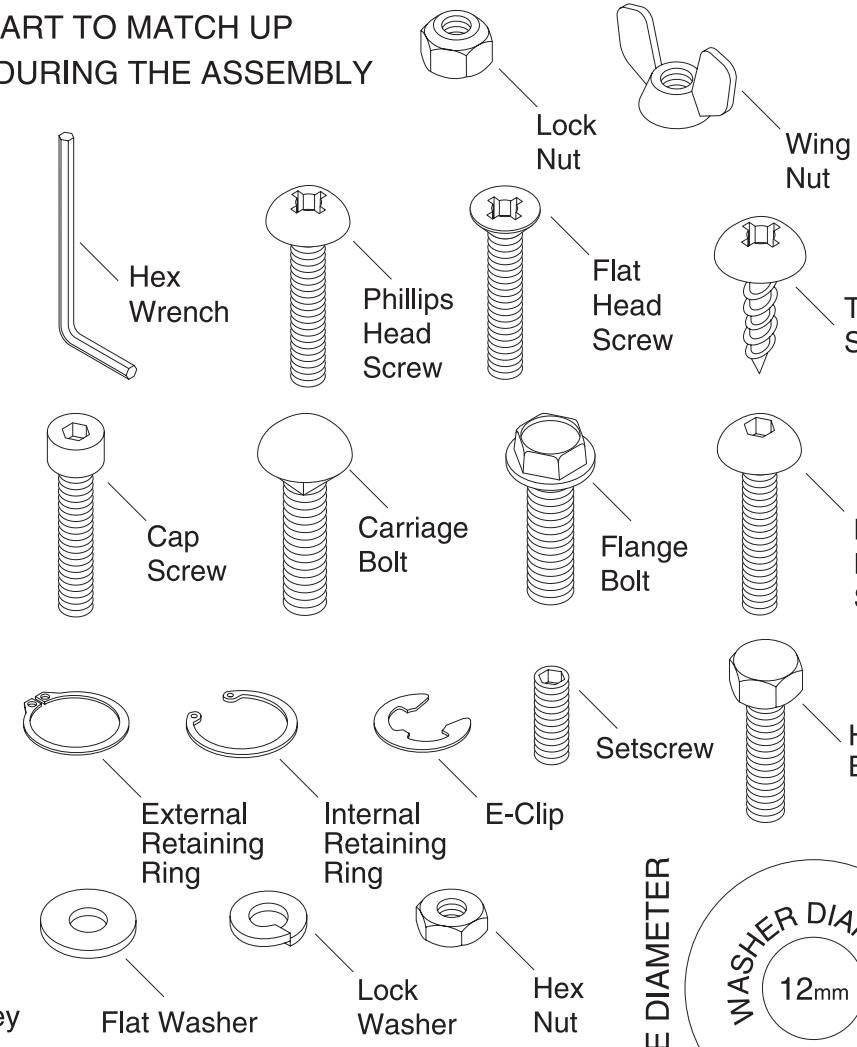
# Hardware Recognition Chart

USE THIS CHART TO MATCH UP HARDWARE DURING THE ASSEMBLY PROCESS.

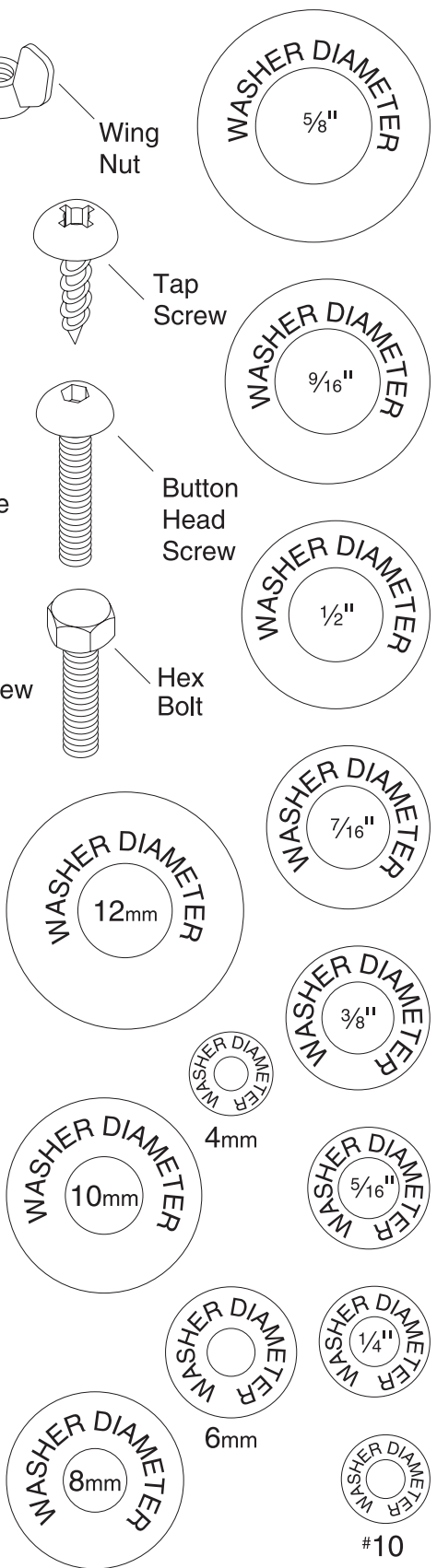
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"

- 4mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm




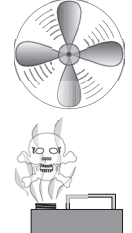
WASHERS ARE MEASURED BY THE INSIDE DIAMETER



# Clean Up

The unpainted surfaces are coated with a waxy oil to prevent corrosion during shipment. Remove this protective coating with a solvent cleaner or degreaser shown in **Figure 4**. For thorough cleaning, some parts must be removed. **For optimum performance from your machine, clean all moving parts or sliding contact surfaces.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner that may damage painted surfaces. Always follow the manufacturer's instructions when using any type of cleaning product.

	<p><b>! WARNING</b> Gasoline and petroleum products have low flash points and can explode or cause fire if used to clean machinery. <b>DO NOT</b> use these products to clean the machinery.</p>
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	<p><b>! CAUTION</b> Many cleaning solvents are toxic if inhaled. Minimize your risk by only using these products in a well ventilated area.</p>
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## G2544—Solvent Cleaner & Degreaser

A great product for removing the waxy shipping grease from your machine during clean up.

<p>Call <b>1-800-523-4777</b> To Order</p>	
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**Figure 4.** Cleaner/degreaser available from Grizzly.

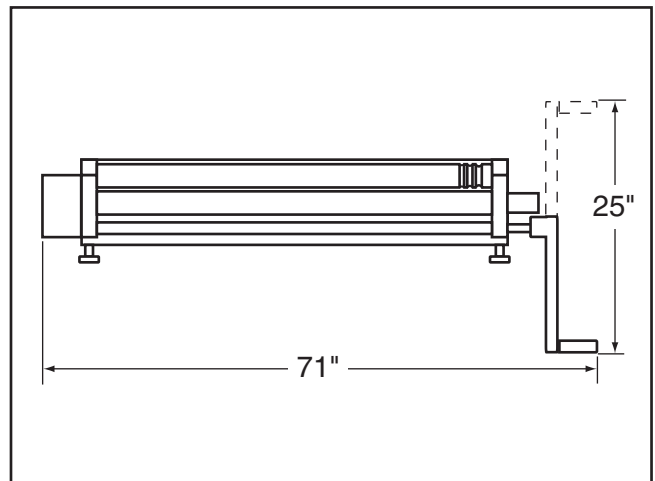
# Site Considerations

## Floor Load

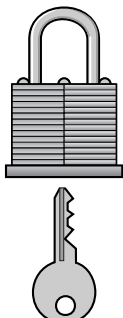
Refer to the **Machine Data Sheet** for the weight and footprint specifications of your machine. Some workbenches may require additional reinforcement to support both the machine and workpiece.

## Placement Location

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 5** for the minimum working clearances.



**Figure 5.** Minimum working clearances.

	<p><b>! CAUTION</b> Children and visitors may be seriously injured if unsupervised around this machine. Lock entrances to the shop or disable start switch or power connection to prevent unsupervised use.</p>
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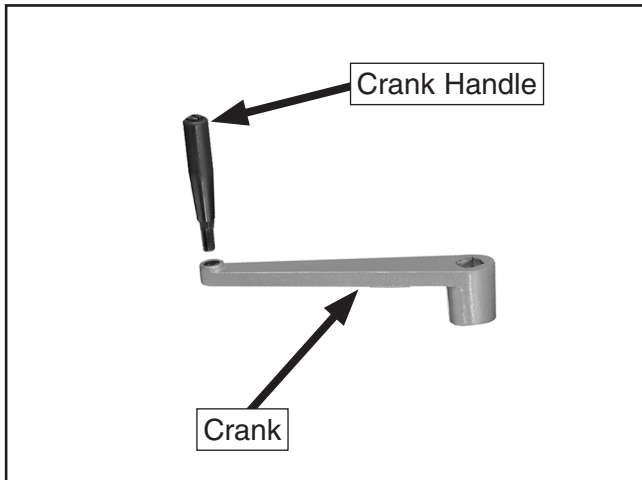


# Assembly

The Model G5771 comes from the factory almost fully assembled. All that is required to assemble are the crank and handle.

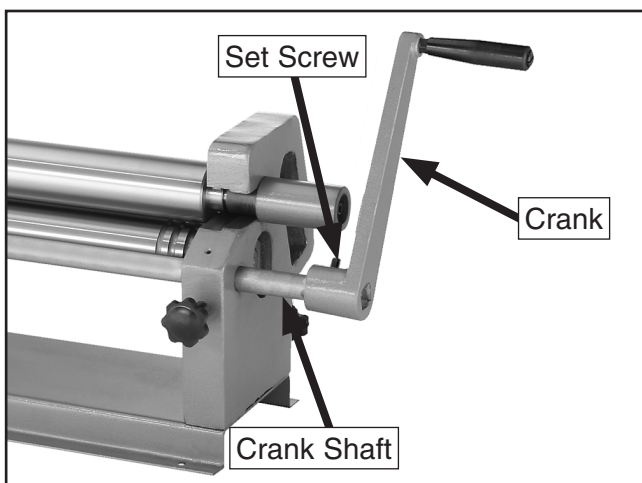
## To assemble your machine:

1. Thread the crank handle into the small end of the crank and tighten, as shown in **Figure 6**.



**Figure 6.** Crank assembly.

2. Slide the crank onto the crank shaft until the crank stops against the beveled shoulders of the shaft. Tighten the set screw to secure the crank in place (**Figure 7**).

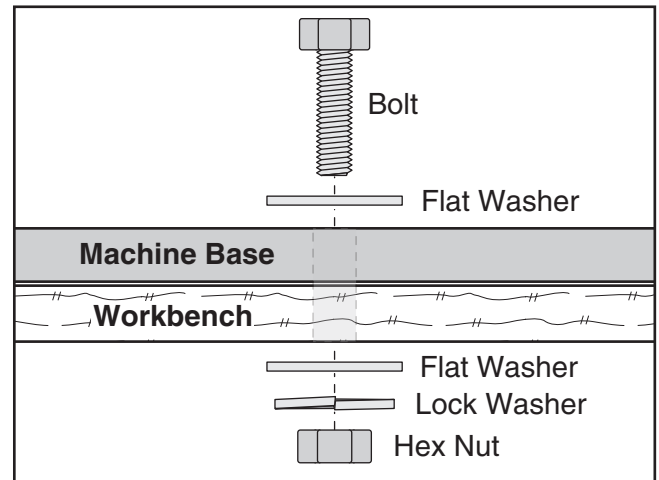


**Figure 7.** Crank mounting.

# Mounting

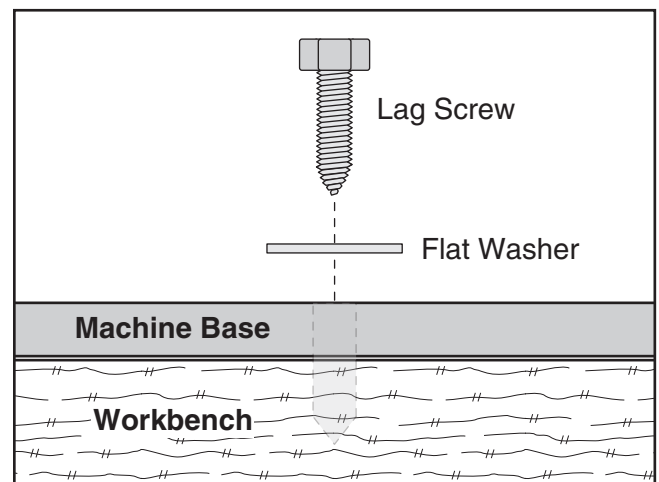
Once you have confirmed that your machine is assembled and functioning properly, mount it to a workbench through the holes in the base.

The strongest mounting option is a "Through Mount" where holes are drilled all the way through the workbench, and hex bolts, washers, and hex nuts are used to secure the slip roll to the workbench.



**Figure 8.** Example of a through mount setup.

Another option for mounting is a "Direct Mount" where the machine is simply secured to the workbench with a lag screw.



**Figure 9.** Example of a direct mount setup.

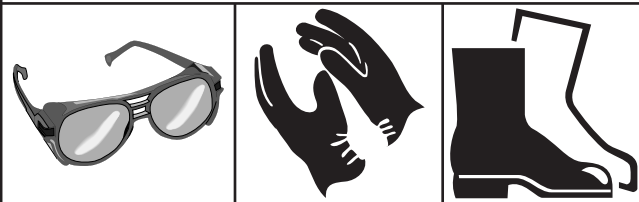


# SECTION 3: OPERATIONS

## Operation Safety

### **!WARNING**

Damage to your eyes, hands and feet could result from using this machine without proper protective gear. Always wear safety glasses, leather gloves, and steel toe footwear when operating this machine.



### **NOTICE**

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

## Basic Controls

Use the descriptions and figures below to become familiar with the basic controls of your slip roll.

**Thickness Adjust Knob:** Raises and lowers the lower roller to adjust for thicknesses of different workpieces.

**Radius Adjust Knob:** Raises and lowers the rear roller to create smaller and larger radius bends.

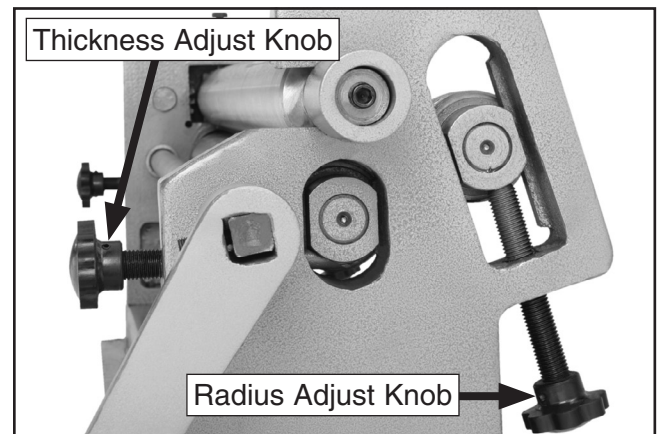


Figure 10. Adjustment knobs.

**Removable Bushing:** Slides out to allow removal of the upper roller to facilitate the unloading of cylindrical workpieces.

**Crank:** Turns the rollers, feeding the workpiece through the machine.

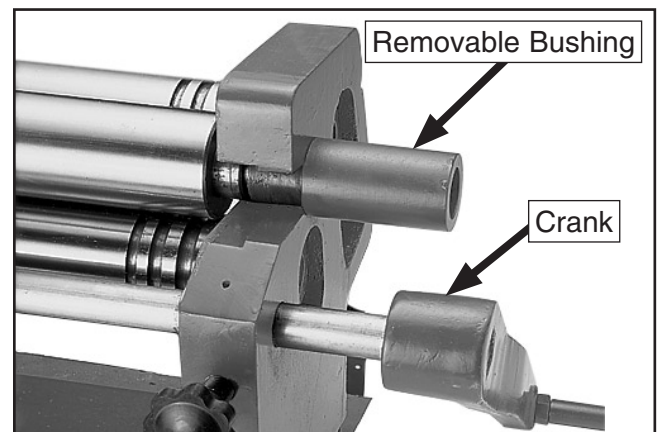


Figure 11. Controls.



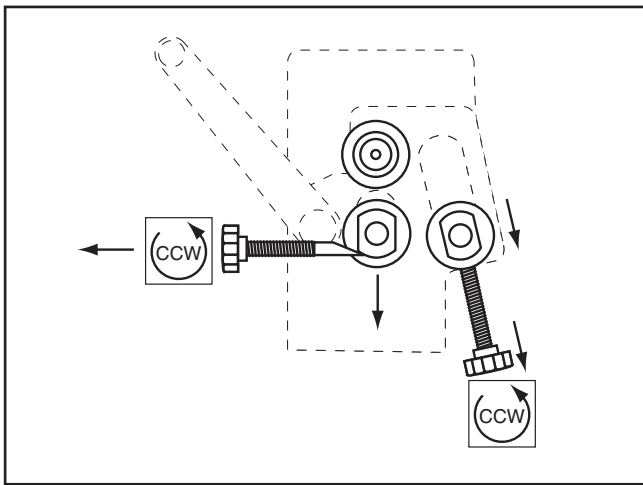


# Preparation

Before every use, follow these procedures to set up your slip roll for safe, accurate, and efficient use.

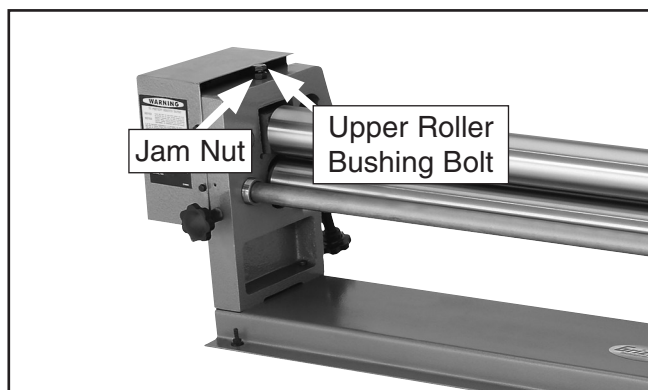
## To prepare the slip roll for use:

1. Turn the thickness adjust knob to lower the lower roller to approximately  $\frac{1}{4}$ " below the upper roller. Use calipers or a spacer to set the distance between the rollers evenly at each end (**Figure 12**).



**Figure 12.** Slip roll preparation.

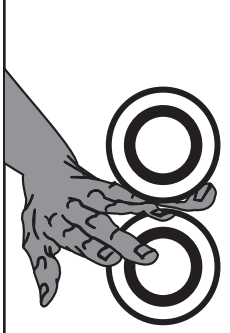
2. Lower the rear roller until it is approximately even with the lower roller. Use calipers or a spacer to set the distance between the rear roller and upper roller evenly at each end.
3. Make sure the upper roller bushing bolt is threaded into the upper roller bushing and the jam nut is tightened against the cast-iron base (**Figure 13**).



**Figure 13.** Upper roller bushing.

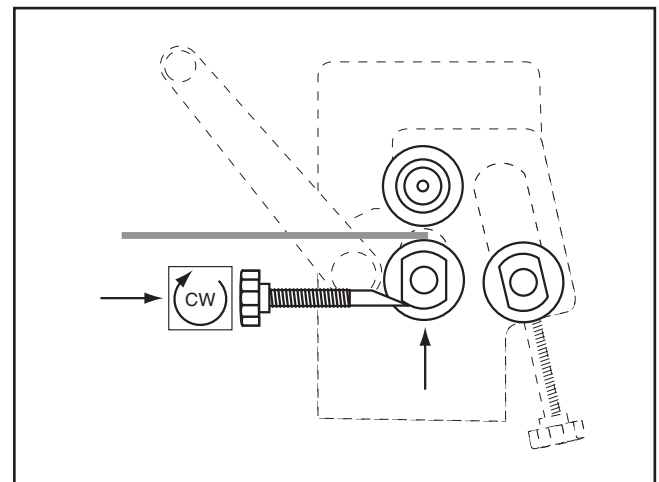
# Flat Rolling

The Model G5771 can be used to flat roll sheet metal up to 16 gauge. This can be done to straighten, flatten, and slightly reduce the thickness of workpieces.

	<p><b>CAUTION</b></p> <p>The main rollers of this machine present a pinching hazard. Make sure no body part or clothing is near the area between the rollers. Failure to follow this warning may result in fingers, hair, or clothing being pulled into the machine, causing personal injury.</p>
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## To flat roll a workpiece:

1. Place the workpiece between the upper and lower rollers, as shown in **Figure 14**. Turn the thickness adjust knobs to lift the lower roller until the workpiece is held snug between the upper and lower rollers. Be sure to turn the thickness adjust knobs equal amounts.

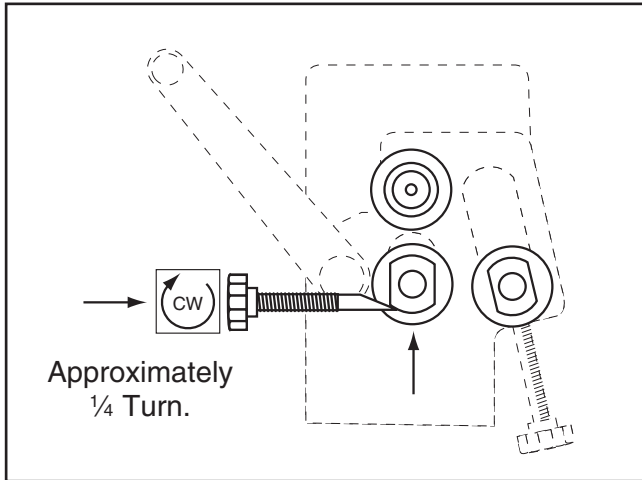


**Figure 14.** Raising lower roller for flat rolling.



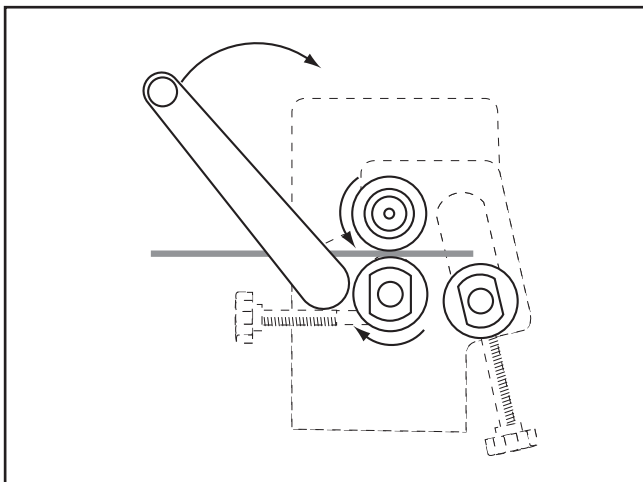


- Remove the workpiece from between the rollers, then raise the lower roller slightly by rotating each thickness adjust knob approximately  $\frac{1}{4}$  turn. Also, make sure the rear roller is lowered completely and will not interfere with the workpiece as it exits the machine (**Figure 15**).



**Figure 15.** Raising lower roller  $\frac{1}{4}$  turn.

- With the help of an assistant, feed the workpiece into the rollers while turning the crank (**Figure 16**).



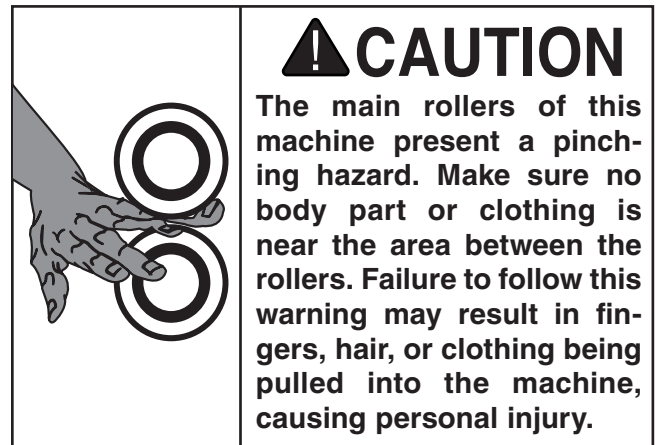
**Figure 16.** Flat rolling the workpiece.

- Continue processing the workpiece by repeating **Steps 2** and **3** until the desired results are produced.

## Creating Bends

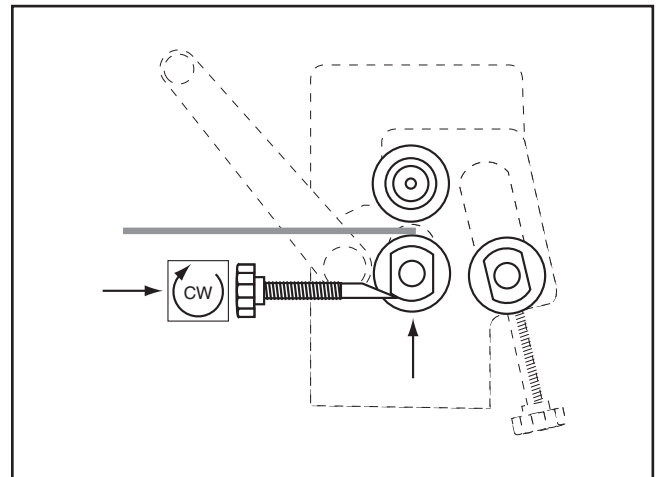
The Model G5771 can easily create constant-radius bends in sheet metal up to 16 gauge.

**Note:** The method for creating a specific radius is a trial-and-error process. Due to the many variations among metal workpieces, no single positioning will create the same curve on all materials. We recommend using scrap pieces the same dimensions and material as your final workpiece until the desired curve is achieved.



**To create a bend in a workpiece:**

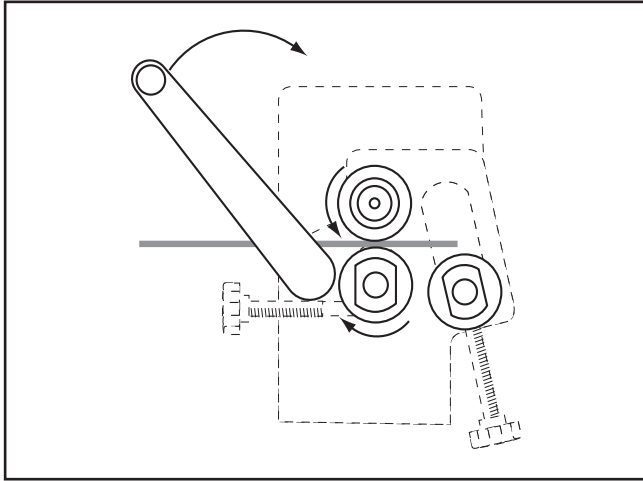
- Place the workpiece between the upper and lower rollers, as shown in **Figure 17**. Turn the thickness adjust knobs to lift the lower roller until the workpiece is held snug between the upper and lower rollers. Be sure to turn the thickness adjust knobs equal amounts.



**Figure 17.** Raising lower roller.

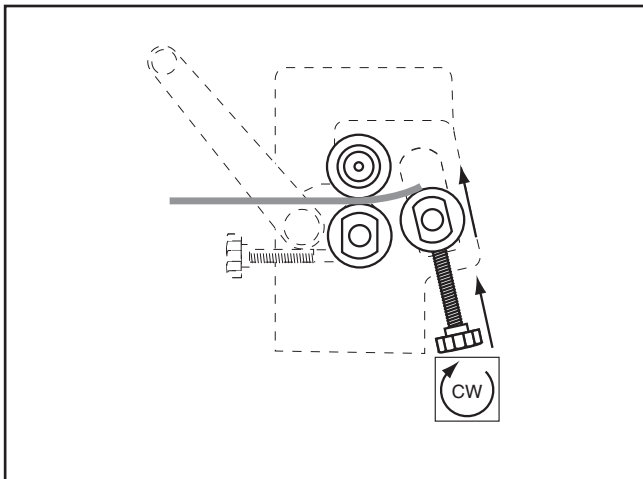


- Turn the crank clockwise to feed the workpiece until its edge is directly above the rear roller, as shown in **Figure 18**.



**Figure 18.** Feeding the workpiece.

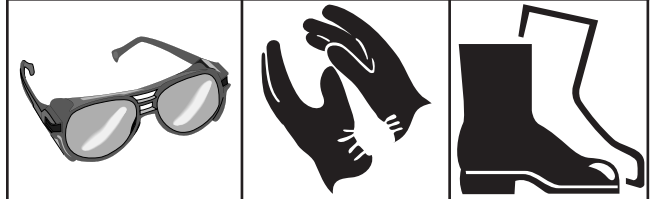
- Turn the radius adjust knobs to lift the rear roller until the desired radius bend is reached (**Figure 19**). Make sure to turn the knobs equal amounts so the rear roller is always parallel with the other rollers. Failure to do so will create a larger radius on one end than the other, resulting in a cone or spiral shape.



**Figure 19.** Setting the radius.

## **! WARNING**

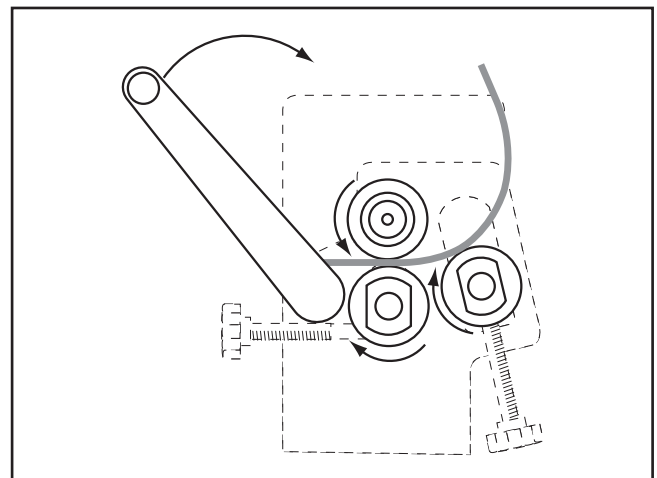
This machine poses a crushing hazard if workpieces are not properly supported when exiting the rollers. If necessary, get assistance to support the workpiece. Make sure all helpers are wearing safety glasses, leather gloves, and steel toed footwear when assisting in the use of this machine.



- Turn the crank to process the material through the slip roll. Continue turning until the workpiece is completely through the upper and lower rollers (**Figure 20**).

## **! CAUTION**

Depending on the size and shape of your workpiece, you may need assistance to support the workpiece as it exits the machine. Failure to adequately support the workpiece may result in the workpiece falling, causing crushing injuries.



**Figure 20.** Processing the workpiece.



# Creating Cylinders

The Model G5771 Slip Roll can be used to easily and accurately create cylinders.

If you know the diameter of the cylinder you want to create, use the formula below to calculate the length of material needed.

$$C = \pi D$$

C=Circumference  
(Length of Material Needed)

$\pi$ =Pi (Approximately 3.142)

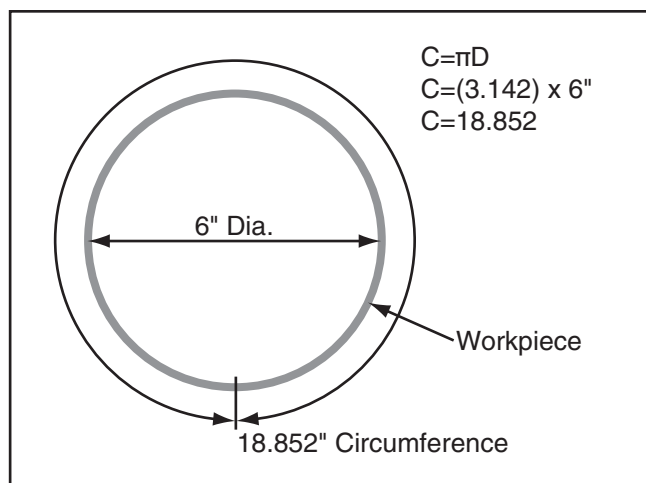
D=Diameter

**Example:** Suppose you want to create a 6" diameter cylinder. You would use the above formula as follows:

$$C = \pi D$$
$$C = (3.142) \times 6"$$
$$C = 18.852"$$

The result of 18.852" indicates that you need to start with a piece of sheet metal that is approximately 18.852" in length in order to create a 6" diameter cylinder.

You can use the slip roll to create a bend with the correct radius so that the two ends meet, forming a 6" diameter cylinder (**Figure 21**).



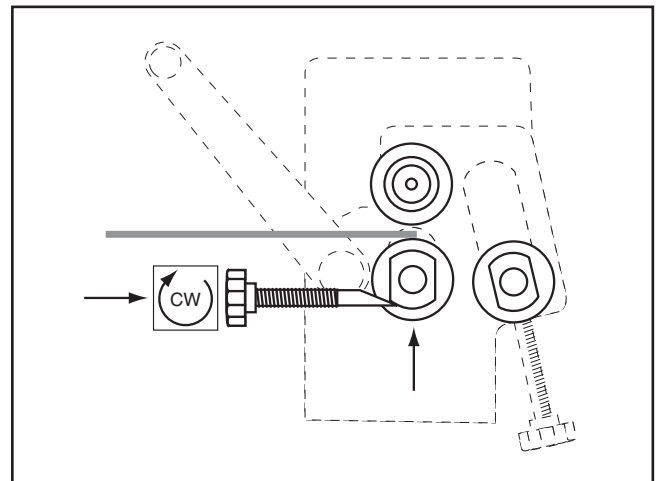
**Figure 21.** Calculating circumference example.

Once you have the necessary length workpiece, follow the steps below to create the cylinder.

**Note:** The method for creating a specific radius is a trial-and-error process. Due to the many variations among metal workpieces, no single positioning will create the same curve on all materials. We recommend using scrap pieces the same dimensions and material as your final workpiece until the desired curve is achieved.

**To create a cylinder:**

1. Place the workpiece between the upper and lower rollers, as shown in **Figure 22**. Turn the thickness adjust knobs to lift the lower roller until the workpiece is held snug between the upper and lower rollers. Be sure to turn the thickness adjust knobs equal amounts.

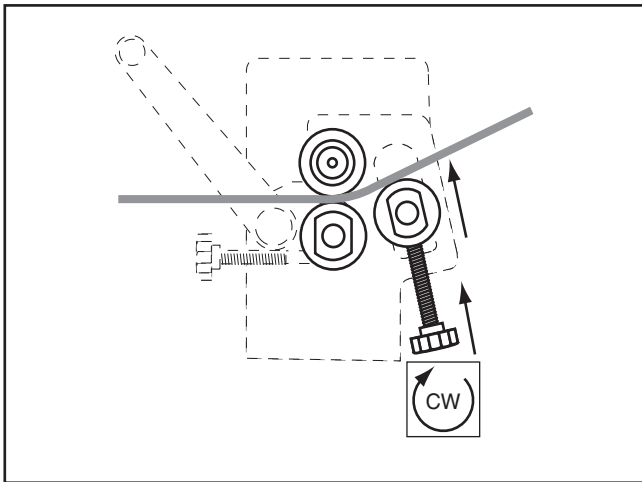


**Figure 22.** Raising lower roller.



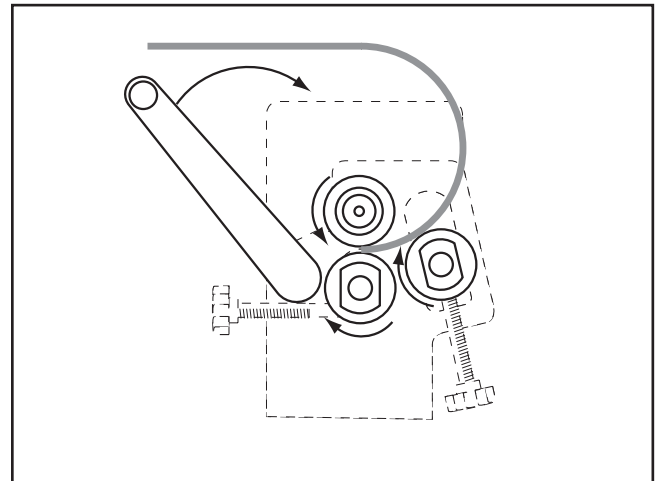
2. Turn the crank clockwise to feed the workpiece until it is approximately half way through the rollers.
3. Turn the radius adjust knobs to lift the rear roller until the desired radius bend is reached (**Figure 23**). Make sure to turn the knobs equal amounts so the rear roller is always parallel with the other rollers. Failure to do so will create a larger radius on one end than the other, resulting in a cone shape.

**Note:** Always err on the side of making the radius too large rather than too small. It is easy to decrease the radius but very difficult to increase the radius later.



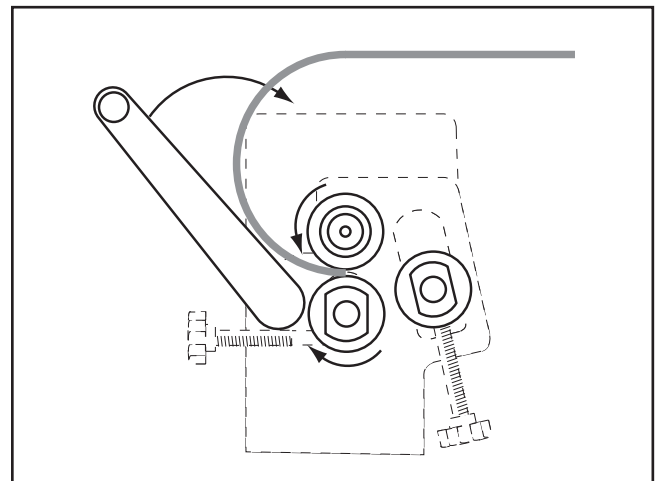
**Figure 23.** Setting the radius.

4. Turn the crank to process the material through the slip roll. Continue turning until the workpiece is completely through the upper and lower rollers (**Figure 24**).

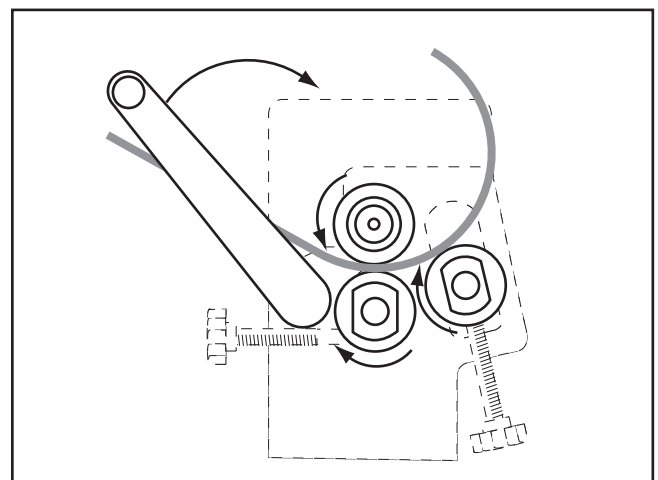


**Figure 24.** Processing the workpiece.

5. Rotate the workpiece 180°, insert the curved end into the slip roll, then process the workpiece through the machine, as shown in **Figures 25 and 26**.



**Figure 25.** Re-inserting the workpiece.



**Figure 26.** Creating the cylinder.

## **⚠ CAUTION**

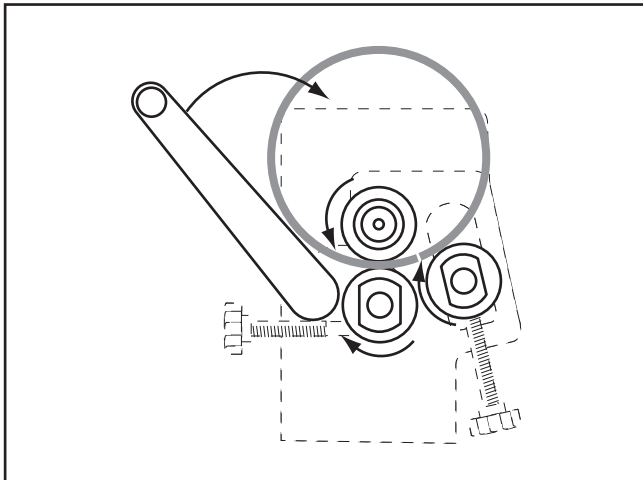
Depending on the size and shape of your workpiece, you may need assistance to support the workpiece as it exits the machine. Failure to adequately support the workpiece may result in the workpiece falling, causing crushing injuries.



6. Continue to process the workpiece until the cylinder is formed, as shown in **Figure 27**.

—If the ends of the cylinder do not meet, lift the rear roller equally at both ends, then process the entire cylinder through the slip roll again. Repeat as necessary.

—If the ends of the cylinder overlap, remove the cylinder as described in **Removing Workpiece on Page 20**. Then, either attempt to increase the radius by manually bending it, or scrap the workpiece. Lower the rear roller equally at both ends then process a new workpiece through the slip roll. Repeat this step as necessary.



**Figure 27.** Finishing the cylinder.

7. Remove the workpiece as described in **Removing Workpiece on Page 20**.

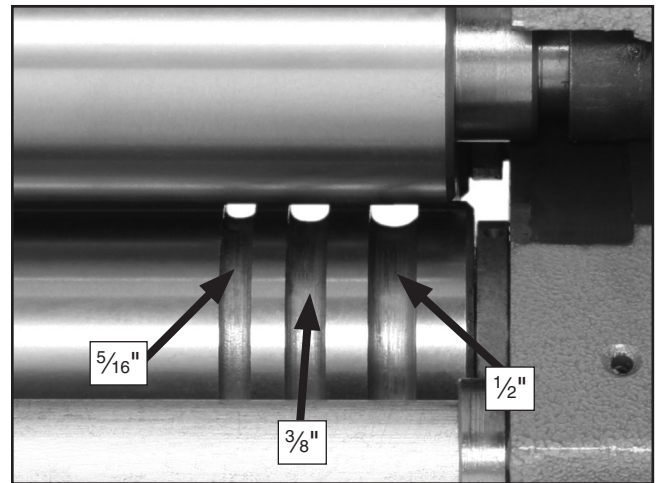
## Bending Wire

The Model G5771 Slip Roll can be used to shape wires, rods, and small-diameter tubing.

### To use the wire grooves:

1. Place your workpiece into the smallest possible groove on the wheel. The three sizes are  $\frac{5}{16}$ " ,  $\frac{3}{8}$ " , and  $\frac{1}{2}$ " (**Figure 28**).

**Example:** Suppose you want to bend a piece of  $\frac{1}{4}$ " rod. Though it would fit in any of the three grooves, you would use the  $\frac{5}{16}$ " groove since it is the smallest possible groove that the rod will fit into.



**Figure 28.** Wire grooves.

2. Process the material through the machine as described in **Creating Bends on Page 15**.

—If you want to make a loop of wire, follow the instructions in **Creating Cylinders on Page 17**.

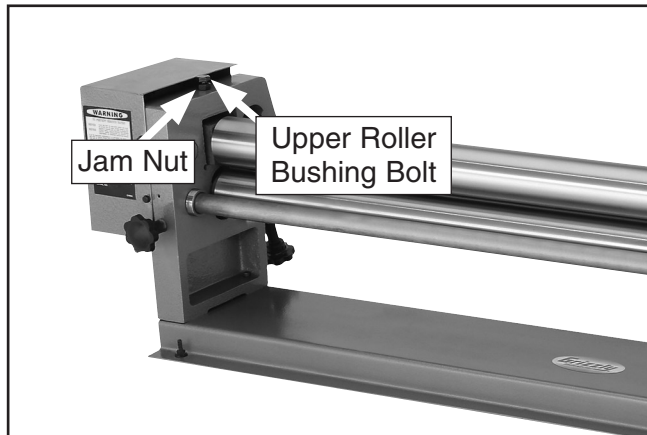
**Note:** *The wire grooves can also be used when rolling sheet metal that has a wire bead at one end.*



# Removing Workpiece

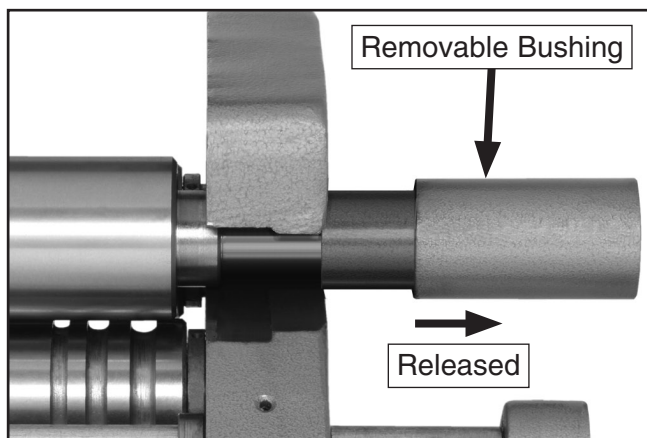
## To remove cylindrical workpieces:

1. Loosen the hex bolt and jam nut that secure the upper roller at the gearbox (**Figure 29**).



**Figure 29.** Hex bolt and jam nut.

2. Slide the removable bushing outward. This will release the upper roller from the stand (**Figure 30**). Do not yet attempt to remove the upper roller.

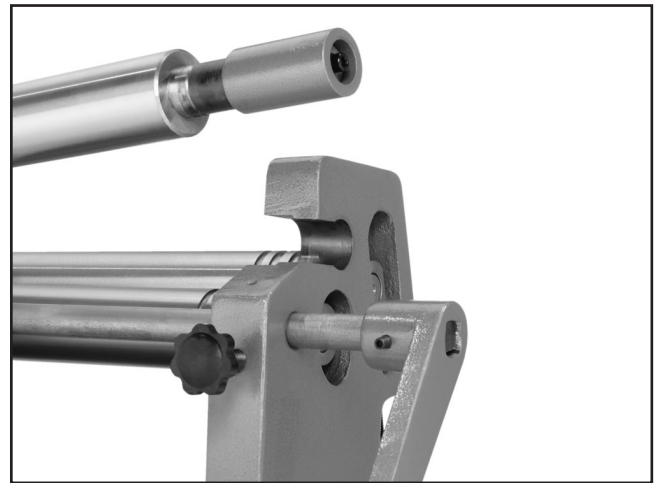


**Figure 30.** Removable bushing release.

## **CAUTION**

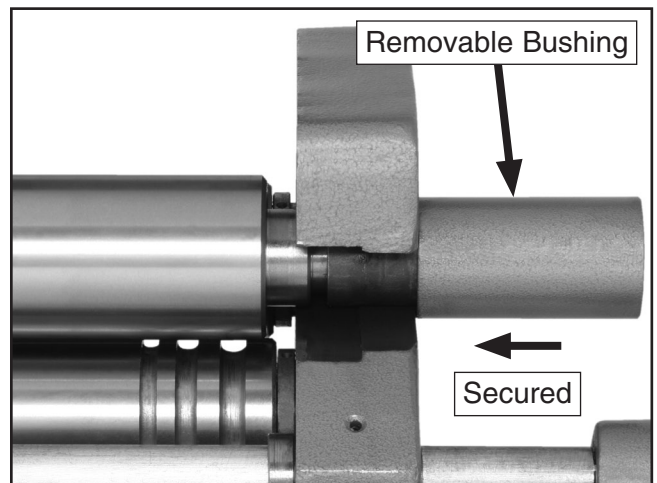
The components of this machine are very heavy and workpieces can be cumbersome and have sharp edges. Always wear gloves and fully support components and workpieces. Get help if necessary. Failure to do this may result in personal injury.

3. With the help of an assistant, slide and lift the upper roller out from the base. Remove the workpiece from the upper roller, then place the upper roller back onto the base (**Figure 31**).



**Figure 31.** Releasing upper roller.

4. Move the upper roller back into position and slide the removable bushing in to secure the upper roller (**Figure 32**).



**Figure 32.** Securing upper roller.

5. Center the roller at the gearbox end and thread the hex bolt back into the upper roller bushing. Then, tighten the jam nut against the base to lock the hex bolt in place.





# SECTION 4: ACCESSORIES

## G5618—Deburring Tool with two Blades

The quickest tool for smoothing freshly sheared metal edges. Comes with two blades, one for steel and aluminum and one for brass and cast iron.



Figure 33. Model G5618 Deburring tool.

## G2871—Boeshield® T-9 12 oz Spray

## G2870—Boeshield® T-9 4 oz Spray

This ozone friendly protective spray penetrates deep and really holds up against corrosive environments. Lubricates metals for months and is safe for use on most paints, plastics, and vinyls.



Figure 34. Boeshield® T-9 spray.

## H6073—Deluxe Power Snip

Lightweight aluminum cast handles. Full 3½" length of cut. Replaceable steel blades. Fully enclosed finger loops protect hands from sharp edges. Long handles provide plenty of leverage. Multi-purpose snip for sheet metal, vinyl and plastic.



Figure 35. Model H6073 Deluxe Power Snip.

## G5562—SLIPIT® 1 Qt. Gel

## G5563—SLIPIT® 12 oz Spray

Used on cast iron table surfaces and other unpainted metal surfaces to reduce sliding friction and hangups. This product also reduces rust and prevents resin build-up.



Figure 36. SLIPIT® gel and spray.

Call 1-800-523-4777 To Order



### **G4956—Super Nibbler**

The super nibbler is just the ticket for cutting sheet metal up to  $\frac{3}{64}$ " thick. Extremely narrow headed design allows cuts in hard-to-reach areas, yet still features a safety guard to prevent flying splinters. 10 $\frac{1}{4}$ " overall.



**Figure 37.** Model G4956 Super Nibbler.

### **H5958—Sheet Metal Pliers**

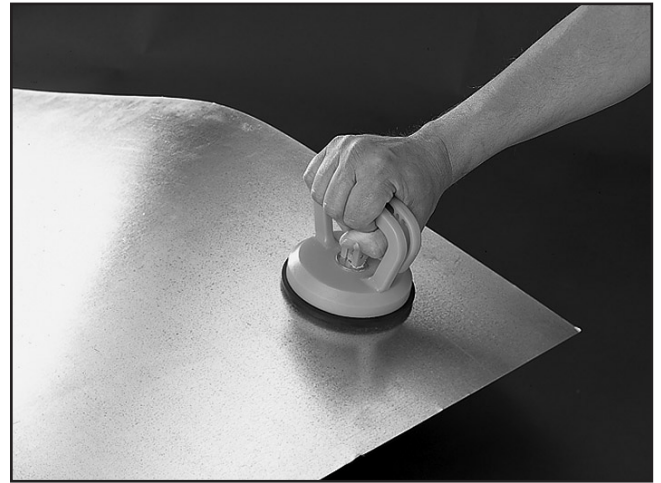
For bending and forming sheet metal. Jaws are 3 $\frac{1}{2}$ " side. Rubber grips. Overall length is 8". Ideal for HVAC Installers.



**Figure 38.** Model H5958 Sheet Metal Pliers.

### **G8781—4 $\frac{1}{2}$ " Suction Cup**

Handle plate glass, glass mirrors and sheet metal with safety and security. Simple had lever action provides tremendous gripping power on any flat, smooth material. Buy two Suction Cups for two-handed control!



**Figure 39.** Model G8781 4-1/2" Suction Cup.

### **H6131—Heavy-Duty Hand Riveter**

Whether you're a full time sheet metal fabricator, or just making occasional repairs, you might as well invest in the best. This Heavy-Duty Hand Riveter with reinforced cast construction will be one of your most dependable tools.



**Figure 40.** Model H6131 Heavy-Duty Hand Riveter.

**Call 1-800-523-4777 To Order**





# SECTION 5: MAINTENANCE

## Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

### Daily Check:

- Loose mounting bolts.
- Any other unsafe condition.

### Weekly Maintenance:

- Clean machine.
- Lubricate gears.
- Lubricate bushings.

## Cleaning

Cleaning the Model G5771 is relatively easy. Periodically wipe down the machine to remove dust and oil. Treat all unpainted cast iron and steel with a non-staining lubricant after cleaning.

## Unpainted Cast Iron

Protect the unpainted cast iron surfaces on the machine by wiping it clean after every use—this ensures rust-promoting debris does not remain on bare metal surfaces.

Keep the machine rust-free with regular applications of products like SLIPIT®, or Boeshield® T-9 (see **Section 5: Accessories** on **Page 21** for more details).

## Lubrication

Lubricating the Model G5771 consists of applying lubricant to the gears, adjustment screws, and the roller bushings.

### Grease Locations (Figure 41)

Remove the gear cover and brush a light coat of multi-purpose grease on the gear teeth. Turn the crank to disperse the grease. Also apply grease to the roller adjustment screws.

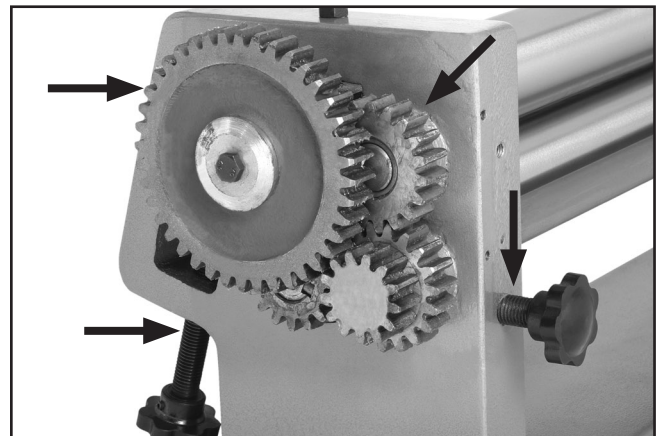


Figure 41. Grease locations.

### Oiling Bushings (Figure 42)

Apply several drops of SAE 30 or equivalent oil from an oil can into the oil holes at both ends of each roller. Turn the crank several times to disperse the oil. Wipe off excess oil.

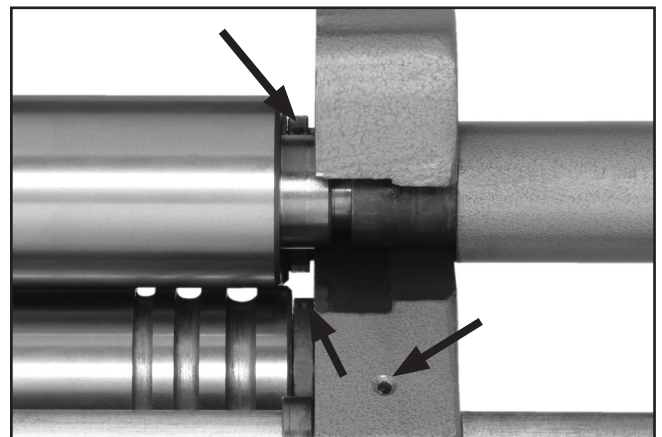


Figure 42. Oil locations.



# SECTION 6: SERVICE

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Review the troubleshooting and procedures in this section to fix or adjust your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

## Troubleshooting

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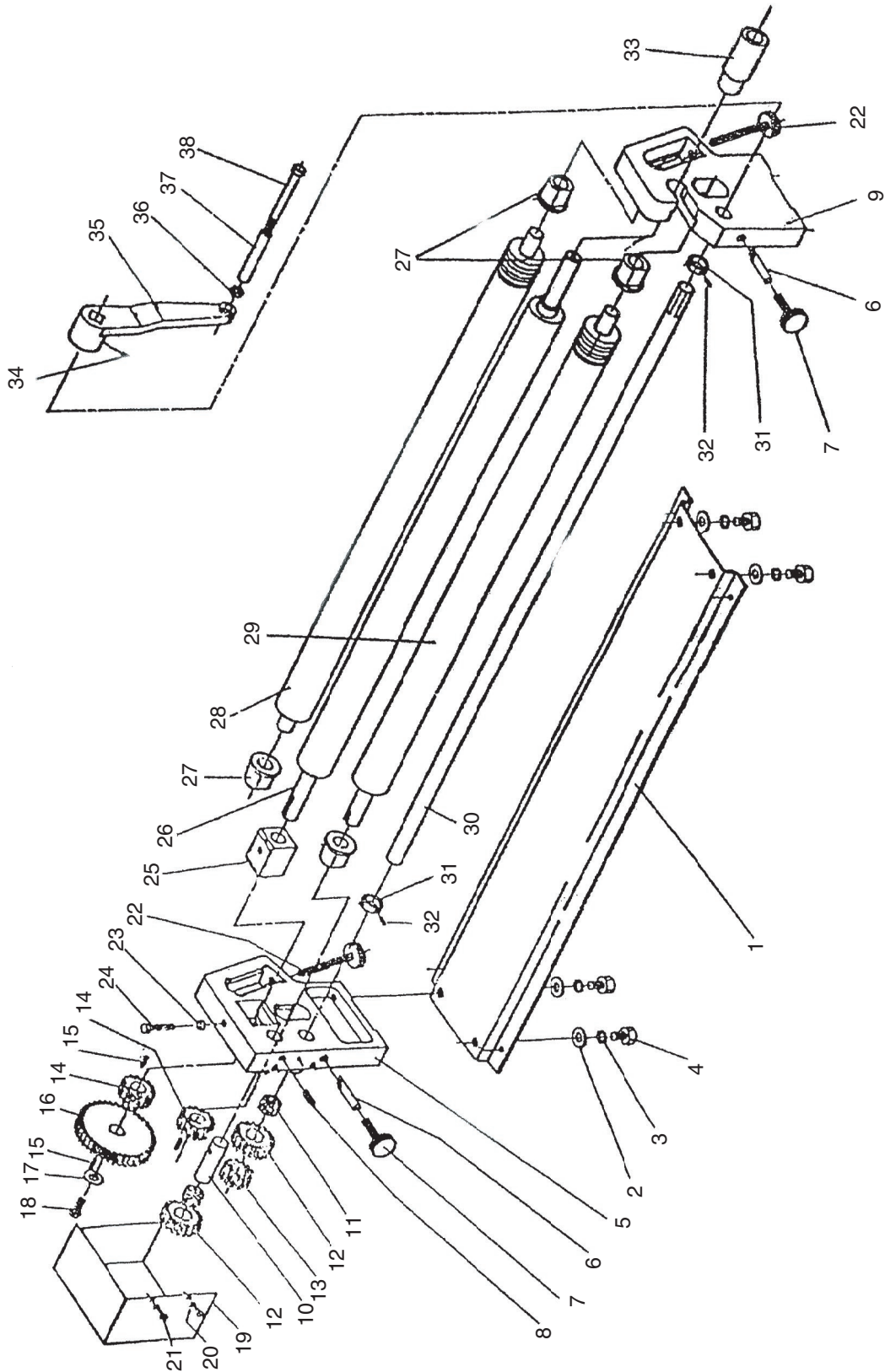
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### Operations

Symptom	Possible Cause	Possible Solution
Slip roll creates cones when trying to create cylinders.	1. Rollers are not parallel.	1. Adjust rear roller adjustment knobs as necessary to be sure the rear roller and upper roller are parallel.
A noticeable crease is formed in the workpiece.	1. Excessive pressure applied in one spot.	1. Reduce the radius and perform the bend in several passes.
Crank does not turn upper and lower rollers.	1. Gearbox end of upper roller is not secure. 2. Gears are damaged.	1. Re-center the bushing and secure the hex bolt and jam nut ( <b>Step 5 on Page 20</b> ). 2. Check/Replace gears.
Slip roll does not bend material.	1. Machine capacities exceeded. 2. Rear roller not engaged.	1. Use materials within the capacity of the slip roll. 2. Check/Adjust rear roller.



# Parts Breakdown



# Parts List

REF	PART #	DESCRIPTION
1	P5771001	BASE
2	PW06M	FLAT WASHER 12MM
3	PLW05M	LOCK WASHER 12MM
4	PB75M	HEX BOLT M12-1.75 X 35
5	P5771005	LIFT STAND
6	PK19M	KEY 5 X 5 X 14
7	P5771007	SETTING KNOB
8	P5771008	SET SCREW M10 X 30
9	P5771009	RIGHT STAND
10	P5771010	GEAR LOCKING SHAFT
11	P5771011	BEARING 30 X 38 X 24
12	P5771012	GEAR 19T
13	P5771013	GEAR 13T
14	P5771014	GEAR 16T
15	P5771015	KEY B10 X 25
16	P5771016	GEAR 40T
17	PW04M	FLAT WASHER 10MM
18	PB14M	HEX BOLT M10-1.5 X 35
19	P5771019	GEAR COVER

REF	PART #	DESCRIPTION
20	PLW03M	LOCK WASHER 6MM
21	PB18M	HEX BOLT M6-1 X 15
22	P5771022	FEED ROLLER KNOB
23	PB09M	HEX BOLT M8-1.25 X 20
24	P5771024	HEX SCREW M12 X 65
25	P5771025	ROLLER #1 BASE
26	P5771026	ROLLER #1
27	P5771027	ROLLER BASE
28	P5771028	FEED ROLLER
29	P5771029	ROLLER #2
30	P5771030	SHAFT
31	P5771031	HANDLE LOCKING BUSH
32	PSS20M	SET SCREW M8-1.25 X 8
33	P5771033	ROLLER #1 BUSHING M10 X 15
34	PSS10M	SET SCREW M10-1.5 X 20
35	P5771035	CRANK HANDLE
36	PN03M	HEX NUT M8-1.25
37	P5771037	GRIP
38	P5771038	GRIP SHAFT





# WARRANTY CARD

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 Model # \_\_\_\_\_ Order # \_\_\_\_\_ Serial # \_\_\_\_\_

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 Card Deck                               Website                       Other:

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<input type="checkbox"/> Handy	<input type="checkbox"/> Practical Homeowner	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Live Steam	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
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<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Shotgun News	

3. What is your annual household income?

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 \$50,000-\$59,000                       \$60,000-\$69,000                       \$70,000+

4. What is your age group?

20-29                                       30-39                                       40-49  
 50-59                                       60-69                                       70+

5. How long have you been a woodworker/metalworker?

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7. Do you think your machine represents a good value?                       Yes                       No

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**Note: We never use names more than 3 times.**                       Yes                       No

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# WARRANTY AND RETURNS

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We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

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